

Date: Tuesday, 7/1/2008 2:33:03 PM
User: Kim Johnston

31

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-UTILITY BASKET RH
Job Number : 40180	
Estimate Number : 12433	
P.O. Number :	Part Number : D205541044
This Issue : 7/1/2008 S.O. No. :	Drawing Number : IIN D205-541 REV G
Prsht Rev. : NC	Project Number :
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : G
Previous Run : 37413	Material :
Written By : <u>JD 08.07.01</u>	Due Date : 7/30/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JD 08.07.01</u>	
Comment : Est Rev:C Re-Format 02-08-30 KJ Est Rev:D chg to revG Ecn 1157 08-03-19 DD verified by:	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JD 08.7.08



Comment: Photocopy bluefile & type labels per PPPD205-541-044 CHG002

2.0 40180A 350/212/130 BASKET LID



Comment: Sub-Component 350/212/130 BASKET LID
1 x D2512 Batch 40180A

EP 08/07/21 @

3.0 40180B 212 BASKET BASE ASSY RH



Comment: Sub-Component 212 BASKET BASE ASSY RH
1 x D3053-042 Batch 40180B

EP 08/07/21 @

4.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Spacer
Batch: 37521

PO

5.0 D2258300 Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Placard
Batch: 37538

EC 5/7/18 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 40180

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 38797

Lu

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 90211

W

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 37671

Lu

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 39153

Lu

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 21139

Lu

11.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107737

W

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107321

Lu 5/7/18 W

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 40180

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104937

lu

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104547

lu

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106815

lu

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107939

lu

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 108138

lu

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M107959

lu

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107650

lu 8/1/18 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: HELI-UTILITY BASKET RH

Job Number: 40180

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M108277

Handwritten signature

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107465

Handwritten signature

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M107978

Handwritten signature

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M107939

Handwritten signature

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: 18071

Handwritten signature 8/7/18 (1)

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg.

Handwritten signature 8/21/21 (2)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten signature 8/21/21 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 40180

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

28.0

D21991

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Struts, 19"
Batch: 38453

29.0

D219923

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 40195

30.0

D219925

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Strut
Batch: 38454

31.0

D2498

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 37542

32.0

D2499

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Bracket
Batch: 37543

33.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing
Batch: 29138

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 40180

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Mounting Lug
Batch: 28 522

W

35.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M107321

W

36.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Bolt
Batch: M105143

W

37.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
Bolt
Batch: M107585

W

38.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M107534

W

39.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: M107013

W

40.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Bolt
Batch: M107321

W 8/7/18 (1)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Date: Tuesday, 7/1/2008 2:33:04 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-UTILITY BASKET RH

Job Number: 40180

Part Number: D205541044

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)
Washer M107939

42.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)
Washer
Batch: M107989

43.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)
Nut
Batch: M107478

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Nut
Batch: M107939

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D205-541-044
Location: F
PPP Rev: F

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
X				D205-541-043	HELI-UTILITY-BASKET, LH
	X			D205-541-044	HELI-UTILITY-BASKET, RH
		X		D205-541-045	HELI-UTILITY-BASKET, LH
			X	D205-541-046	HELI UTILITY-BASKET, RH
2*	2*			D2022-101	SPACER
1	1	1	1	D2199-1	STRUT
1	1	1	1	D2199-23	STRUT
1	1	1	1	D2199-25	STRUT
1*	1*	1*	1*	D2258-300	LABEL
1*	1*	1*	1*	D2332-041	PROP ASSEMBLY
1	1	1	1	D2498	MOUNTING LUG
1	1	1	1	D2499	MOUNTING LUG
1*	1*			D2512	BASKET LID ASSEMBLY
2	2	2	2	D2515	BUSHING
1*	1*	1*	1*	D2530	HANDLE ASSEMBLY
2*	2*	2*	2*	D2535	SPRING
2*	2*	2*	2*	D2537	BUSHING
2*	2*			D2931	BUMPER
1	1	1	1	D3052-1	MOUNTING LUG
1*				D3053-041	BASKET BASE ASSEMBLY, LH
	1*			D3053-042	BASKET BASE ASSEMBLY, RH
		1*		D3712-041	BASKET BASE
			1*	D3712-042	BASKET BASE
		1*		D3713-041	LID ASSEMBLY
			1*	D3713-042	LID ASSEMBLY
		6*	6*	D3723-1	BUSHING
2*	2*	2*	2*	AN3-16A	BOLT
2*	2*			AN4-7A	BOLT
2	2	2	2	AN4-7A	BOLT
3	3	3	3	AN4-12A	BOLT
9	9	9	9	AN4-13A	BOLT
2	2	2	2	AN4-14A	BOLT
		3*	3*	AN4-20A	BOLT
1*	1*	1*	1*	AN4-22A	BOLT
1*	1*	1*	1*	AN4-24A	BOLT
1	1	1	1	AN5-7A	BOLT
1	1	1	1	AN5-13A	BOLT
4*	4*	4*	4*	AN5-17A	BOLT
2*	2*	6*	6*	AN960JD416	WASHER
27	27	27	27	AN960JD416	WASHER
2*	2*	2*	2*	AN960JD416L	WASHER
4*	4*	4*	4*	AN960JD516	WASHER
3	3	3	3	AN960JD516	WASHER
2	2			AN960JD8	WASHER
4*	4*	4*	4*	AN970-4	WASHER

...CONTINUED ON NEXT PAGE

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Revision: G

Date: 08.03.04

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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 40180

...CONTINUED FROM PREVIOUS PAGE

Qty -043	Qty -044	Qty -045	Qty -046	Part Number	Description
2*	2*			MS20600AD4W3	RIVET
2*	2*	2*	2*	MS21042L3	NUT (OR MS21042-3)
4*	4*	5*	5*	MS21042L4	NUT (OR MS21042-4)
16	16	16	16	MS21042L4	NUT (OR MS21042-4)
4*	4*	4*	4*	MS21042L5	NUT (OR MS21042-5)
2	2	2	2	MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

7.0 OPTIONAL EQUIPMENT

Qty -049	Part Number	Description
X	D205-541-049	LINER KIT
1	D2446	SIGN PLATE
1	D2509	LINER (BASE)
1	D2511	LINER (END)
6	MS24693S272	SCREW
6	A3235-020-935	WASHER
6	NAS679A3W	NUT
4	MS20470AD4-8	RIVET
42	MS20600AD4W4	RIVET

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